

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017516**Date Inspected:** 23-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC)**Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No N/A
		Component:	OBG Trial Assembly	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Segment 10AE to Segment 10BE (Longitudinal Diaphragm to Longitudinal Diaphragm)

This QA Inspector witnessed the final bolt tension verification on bolts connecting the Longitudinal Diaphragm to Longitudinal Diaphragm between Panel Points (PP) 88 and PP 81 for Segment 10AE to Segment 10BE at work point E4, Cross Beam side and work point E4 Bike Path side. The QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance. The Inspection was performed against Notification No. 00520 dated October 23, 2010.

The bolt sizes used were M24 x 70 RC Lot # DHGM240010 and the final torque value established was 560 N-m.

The bolt sizes used were M24 x 95 RC Lot # DHGM240021 and the final torque value established was 540 N-m.

The Manual Torque wrench used was Serial No. XO2-666.

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Segment 10BE to Segment 10CE (Longitudinal Diaphragm to Longitudinal Diaphragm)

This QA Inspector witnessed the final bolt tension verification on bolts connecting the Longitudinal Diaphragm to Longitudinal Diaphragm between Panel Points (PP) 91 and PP 92 for Segment 10BE to Segment 10CE at work point E4, Cross Beam side and work point E4 Bike Path side. The QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance. The Inspection was performed against Notification No. 00520 dated October 23, 2010.

The bolt sizes used were M24 x 70 RC Lot # DHGM240010 and the final torque value established was 560 N-m.

The bolt sizes used were M24 x 95 RC Lot # DHGM240021 and the final torque value established was 540 N-m.

The Manual Torque wrench used was Serial No. XO2-666.

Segment 12AE (Plumbness and Flatness after Heat Straightening)

This QA Inspector performed Dimension Control Inspection along with Caltrans QA Inspector Mr. Murugan Manikandan for measuring plumbness and flatness on the deck panel to deck panel diaphragm between U-Rib at following locations

At 2nd, 3rd, 4th, 5th, 6th and 7th locations (reference of numbering taken from cross beam side towards bike path side) on Segment 12AE at Panel Point (PP) 110 after heat straightening.

At 12th, 13th, 14th and 15th locations (reference of numbering taken from cross beam side towards bike path side) on Segment 12AE at Panel Point (PP) 111 after heat straightening.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Lift 10 East (X37B and X37C Brackets)

This QA Inspector performed Dimension Control Inspection along with ABF QA Inspector for the Segment 10AE, Segment 10BE, and Segment 10CE and measured the distance between road barrier bolt hole drilled at X37B and X37C from deck panel to the cope hole at X37B and X37C brackets installed at Corner Assembly at east and west side of the X37B brackets at following locations.

At Panel Points(PP) 85.25 and PP 85.75, Cross Beam side.

At Panel Points(PP) 85.25 and PP 85.75, Bike Path side.

At Panel Points(PP) 86.25 and PP 86.75, Cross Beam side.

At Panel Points(PP) 86.25 and PP 86.75, Bike Path side.

At Panel Points(PP) 87.25 and PP 87.75, Cross Beam side.

At Panel Points(PP) 87.25 and PP 87.75, Bike Path side.

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At Panel Points(PP) 88.25 and PP 88.75, Cross Beam side.

At Panel Points(PP) 88.25 and PP 88.75, Bike Path side.

At Panel Points(PP) 89.25 and PP 89.75, Cross Beam side.

At Panel Points(PP) 89.25 and PP 89.75, Bike Path side.

At Panel Points(PP) 90.25 and PP 90.75, Cross Beam side.

At Panel Points(PP) 90.25 and PP 90.75, Bike Path side.

At Panel Points(PP) 91.25 and PP 91.75, Cross Beam side.

At Panel Points(PP) 91.25 and PP 91.75, Bike Path side.

At Panel Points(PP) 92.25 and PP 92.75, Cross Beam side.

At Panel Points(PP) 92.25 and PP 92.75, Bike Path side.

At Panel Points(PP) 93.25 and PP 93.75, Cross Beam side.

At Panel Points(PP) 93.25 and PP 93.75, Bike Path side.

At Panel Points(PP) 94.25 and PP 94.75, Cross Beam side.

At Panel Points(PP) 94.25 and PP 94.75, Bike Path side.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Bike Path at Bay # 19

This QA Inspector performed Dimension Control Inspection on the Bike Path bottom panel for flatness check and bike path identified as BK4A-011. Inspection was performed after correction by heat straightening.

The QA Inspector measured the flatness using 1500mm long straight edge and observed flatness dimensions within allowable tolerance.

The results of the inspection were informed to Caltrans Lead Inspector Mr. Artur Peterson.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150000422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Math,Manjunath	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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